October 5, 2010 11:51:13 AM



Page 1

Item ID:

D206-642-441

Accept

Setup Start

**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

Required Date: 10/22/10

10/05/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Process Plan:** Approvals:

QC:

Date: 10-10-05 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Start Stop

Stop



Sequence ID/

Operation **Work Center ID** Description Set Up/

0.00

1 0.00

**Run Hours** 

**Tool ID** 

Tool # Plan Code

Accept Reject Qty Qty

Run

Reject Number

Insp. Stamp

**Draw Nbr** 

**Revision Nbr** 

D2650

Rev F

100

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D206-642-441

CHG002

Dart Aerospace	Ltd
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W/O:			W	ORK ORDER CHANG	SES	· · · · · · · · · · · · · · · · · · ·	-			, 4
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Page 2

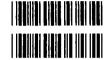
Item ID:

D206-642-441

Accept



Setup Start



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

Start Otv: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

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Process Plan:

Date:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Stop

Reject

Sequence ID/ **Work Center ID** 

110



Skidtubes Skidtubes

Operation **Description**  Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty Number

Insp. Stamp

Skidtubes

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as

A/R - Aluminum Rod - MUI385

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Daili อัก

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

W/O:			W	ORK ORDER CHANG	ES				, .		
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October 5, 2010 11:51:18 AM



Page 3

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

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Date:\_\_\_\_\_

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Stop

Run

Start

Sequence ID/ Work Center ID

115

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

0.00

4)/01/0/0

**Tool ID** 

Tool # Plan Qty Code

Accept Reject Qty

Reject Number Insp. Stamp

116 

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

810/10/14

Memo

Memo

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

10-10-15

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October 5, 2010 11:51:18 AM



Page 4

Item ID:

D206-642-441

Accept

Setup Start

**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Operation

Description

Required Date: 10/22/10

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:\_\_\_\_

Tooling:

**SPC (Y/N):** 

Set Up/

Tool ID

Date:\_

Date:

Start Run

Stop

Stop

Sequence ID/ Work Center ID

130

Quality Control

Memo

QC3- Inspect Part Finish

Run Hours

0.00

0.00

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

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October 5, 2010 11:51:24 AM



Page 5

Item ID:

D206-642-441

Accept.



Setup Start



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID: Customer:** 

Reference:

**Approvals:** 

Process Plan:

**Operation** 

Date: Date:

**Tooling:** 

0.00

0.00

SPC (Y/N):

Date: Date:

Run

Start

Stop

Stop



Set Up/ **Run Hours**  Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

Sequence ID/

Work Center ID

Skidtubes Skidtubes

Description

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Finish Date: 10-10-2/

Sikaflex expiry date: \( \frac{M(\seta/4)}{\left(\seta/0)/\ \)

W/O:		WORK ORDER CHANGES											
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Page 6

Item ID:

D206-642-441

Accept

Accept

Qty

Setup Start

Stop



**Revision ID:** 

Replacement Skidtube Item Name:

**Start Date:** 

10/05/10

QC:

Start Qty: 1.00

Required Date: 10/22/10

Req'd Qty: 1.00



**Cust Item ID:** 

Date:

Date:

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Date: **Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

**Tool ID** 

Code

Tool # Plan

Run Start

Reject

Qty



Stop

Reject

Number

Insp.

Stamp/

Sequence ID/ Work Center ID

150

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

160

Skidtubes Skidtubes

Skidtubes

Memo

0.00

0.00

other side. Use aluminum rod

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the

A/R Aluminum Rod□ M

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.701 deen as per Dwg D2650 Deburr

W/O:			WORK ORDER CHANGES									
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Page 7

Item ID:

D206-642-441

Accept



Setup Start

Stop

Stop

Reject

Number



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Operation

**Description** 

Date:

**Tooling:** 

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

**Tool ID** 

Start Run

Reject

Qty



Insp.

Stamp

Accept

Qty-

Sequence ID/

**Work Center ID** 

170

Skidtubes Skidtubes

HandFinishing

Install D2680-041 Nut Plate as per Dwg D2650

Date:\_\_\_\_\_

0.00

0.00

10-10-26

Tool # Plan

Code

180

Quality Control

QC10- Inspect visual per QSI004- ground welds



190

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

W/O:			W	ORK ORI	DER CHA	NGES				-	
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Page 8

Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

**Start Date:** 

10/05/10

QC:

Start Oty: 1.00

Req'd Qty: 1.00 Required Date: 10/22/10



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: Date:

Tooling:

**SPC (Y/N):** 

-0.00

0.00

Date:

Tool # Plan

Start Run

Reject



Sequence ID/ **Work Center ID** 

200

HandFinish

Hand Finishing

Operation Description

Pressure Wash per QSI005 4.3

Set Up/ **Run Hours** 

10/10/22

Date:

Code

**Qty** Number

Stop

Reject

Insp. Stamp

1. 3. 16 Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in

211

SprayPaint

**Spray Painting** 

0.00

0.00

PRIME B\_115967 PAINT DELFLEET BLUE B 1\550°\ CLEAR DELFLEET B 1\5949

Accept

**Qty** 

M 10 11 03 (1)

221

**Quality Control** 

Memo

QC14- Inspect Spray Paint

W/O:		WORK ORDER CHANGES											
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Page 9

October 5, 2010 11:51:35 AM

Item ID:

D206-642-441

Accept



Setup Start



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

SPC (Y/N):

**Tooling:** 

Set Up/

**Run Hours** 

Date: Tool ID

Tool # Plan

Code

Date:

Run Start

Reject

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Accept

Qty

Stop

Stop



Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID** 

230

HandFinish

Hand Finishing

Operation **Description** 

HandFinishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

- A/R□□Sikaflex-291□ NULLY 69□B Sikaflex expiry date: □ 10/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R □ Sikaflex-291 □ 人//// 0 包記

Sikaflex expiry date: 10/0//

6-Wing Walk as per Dwg D2650-7 and QSI 005 44 ...,

Batch: ///115796

W/O:			W	ORK ORDER	CHANGES		i			
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Item ID:

D206-642-441

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Required Date: 10/22/10

Replacement Skidtube

**Start Date:** 

10/05/10

Start Qty: 1.00

**Req'd Qty:** 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

QC:

Process Plan: \_\_\_\_\_

Operation

Description

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Start Run



Set Up/

**Run Hours** 

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Stop

Insp. Stamp

240

Sequence ID/

**Work Center ID** 

QC Quality Control QC5- Inspect part completeness to step on W/O

Date:

0.00 0.00

0.00

0.00

250

Packaging

Packaging

Packaging

Memo

Memo

Identify and pack for shipping as per PPP D206-642-441

Location: PPP Rev:

260

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

## **Picklist Print**

October 5, 2010 11:51:02 AM

Work Order ID: 62622

D206-642-441 Parent Item:

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Start Qty: 1.00

Required Date: 10/22/10

Page 1

Required Qty: 1.00

**Comments:** 

IPP Rev:H□05.10.11□Added D3429-1 per CHG002 □KJ/CP/JLM

IPP Rev:I 08-05-01 add QC3 DD verified by:EC
IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC

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0.09.27	SS washers	for wearplates	EC vei	rified by:	DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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#### **Picklist Print** Page 2 October 5, 2010 11:51:02 AM Work Order ID: 62622 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube Required Date: 10/22/10 **Start Date:** 10/05/10 Required Qty: 1.00 Start Qty: 1.00 CCR264SS3-3 170 446.0000 Purchased No Each 2 Cherry Rivet Location Loc Oty Loc Code ST311 446 112314 44 113539 113973 398 CR3212-4-03 230 1,888.000 No Purchased Each Cherry Rivet Location Loc Oty Loc Code ST311 1888 111359 5 112314 2 114436 448 114450 71 1362 D2620 Manufactured No 110 Each 8.0000 Skidtube, 206 Skidtube

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 Location
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Work Order ID: 62622  Parent Item: D206-642-441  Parent Item Name: Replacement	t Skidtube						Date: 10/05/	10	Required Date: 10/22/10
D2646	Manufactured	No	·	110	Each	50.0000	Qty: 1.00	1 11	Required Qty: 1.00
Aft Cap			<u>Location</u>	<u>Lo</u>	c Oty	Loc Code		<u> </u>	
blue			FP-4 57332 fp5 61752 FP6		45 45 1 1	1362657	<u></u>	x (	
D2647	Manufactured	No	52663	140	4 Each	66.0000	1	1	-
			Location FP 55352	<u>Lo</u>	66 66	Loc Code			BE 10/10/12
D2649  Cross Bolt Spacer	Manufactured	No		170	Each	65.0000	23	23	
			<u>Location</u> LG	<u>Lo</u>	oc <b>Qty</b> 65	Loc Code			_
			58545 60652		2 4		<u></u>		- -

B 62889

61496

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#### Picklist Print Page 4 October 5, 2010 11:51:03 AM Work Order ID: 62622 Parent Item: D206-642-441 Parent Item Name: Replacement Skidtube Required Date: 10/22/10 **Start Date:** 10/05/10 Required Qty: 1.00 Start Qty: 1.00 230 22 D2651-1 Manufactured Each 622.0000 Plug Location Loc Qty Loc Code 1362638 FP 252 51530 152 100 61751 fpa 370 53349 235 57869 135 D2651-3 230 626.0000 22 Manufactured Each 22 1011/108 O-Ring **Location** Loc Oty Loc Code FP 626 <u>4611</u>4 130 61962 496 D2654-7 Manufactured 160 0.0000 No Each B 62686

170

D2680-041

Nut Plate

Web

Location

Manufactured

No

Loc Qty 29 29

29.0000

Each

W/O:		WORK ORDER CHANGES											
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#### **Picklist Print** Page 5 October 5, 2010 11:51:04 AM Work Order ID: 62622 Parent Item: D206-642-441 Required Date: 10/22/10 Parent Item Name: Replacement Skidtube **Start Date:** 10/05/10 Required Qty: 1.00 Start Qty: 1.00 6.0000 D3535-15 230 Each Manufactured Wearshoe Location Loc Oty Loc Code 1362241 FP18 61241 6 230 Each 19.0000 D3535-23 Manufactured No Wearshoe Location Loc Qty Loc Code FP 61830 7 FP021 20 60231 11 9.0000 230 D3535-37 Manufactured No Each Wearshoe Location Loc Oty Loc Code FP 56101 D3536-15 230 Each 10.0000 Manufactured No

Gasket



Locati	on,	Loc Qty
FP		9
	56055	1
	60875	. 8
FP11		1
	59238	1

Loc Code	بر بر
1362459	

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#### Picklist Print

October 5, 2010 11:51:05 AM

Page 6

Work Order ID: 62622

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D3536-23



Gasket

D3536-37



Gasket

D3537-3

Wearpad -

D3537-1

Manufactured

Manufactured

Manufactured

No

No

Each

8.0000

Location FP011

61237

Loc Qty 8 230 Each

230

1363391

Loc Code

8.0000

Location FP

Location

FP

56102

Loc Oty 230 Each Loc Code

14.0000

10/11/08

Wearpad

Manufactured

Loc Oty Loc Code 13 B62661 3 3 Each 8.0000

Location FP17

60866

Loc Qty

Loc Code 361674

230

W/O:	W/O: WORK ORDER CHANGES									
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October 5, 2010 11:51:05 AM

Work Order ID: 62622 D206-642-441 Parent Item: Parent Item Name: Replacement Skidtube



**Start Date:** 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

MS27039-4-06

Purchased

Purchased

No

230

Each

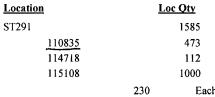
1,585.000

Loc Code

3011101 LA

Screw

No	



Each

108.0000

Loc Code



Screw	

**SCREW** 

MS27039C1-08	Purchased	No

Location	Lo	c Oty
ST292		108
109061		14
115460		94
	230	Each

1,077.000



Locatio	<u>n</u>	Loc Qty
FP		276
	115336	276
ST293		801
	115589	800
	19185	1
	· 17-	

Loc Code MIV 6022

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October 5, 2010 11:51:06 AM

Work Order ID: 62622

Parent Item:

D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 10/05/10

Required Date: 10/22/10

Page 8

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Washer

Purchased

No

230

Each

5,239.000

30/11/08 PK

<b>Location</b>	Loc Qty	Loc Code	4.1
ST297	5239		<u></u>
113524	10		
113737	150		<u> </u>
115000	125		· .
115698	78		
115816	1276		
115832	3600		X60

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QTY QTY QTY QTY PART NUMBER DESCRIPTION D2650-1 SKIDTUBE ASSEMBLY Х Х D2650-3 SKIDTUBE ASSEMBLY Х D2650-5 SKIDTUBE ASSEMBLY D2650-7 SKIDTUBE ASSEMBLY X D2600-1-160 **EXTRUSION** D2654-1 WEB D2654-3 WEB 1 D2654-5 WEB D2654-7 WEB D2646 AFT CAP 1 1 D2647 CAP 17 18 19 23 D2649 CROSS BOLT SPACER 16 PLUG 18 14 22 D2651-1 16 18 14 22 D2651-3 O-RING D2680-041 NUT PLATE 2 2 D3286-1 DOUBLER 2 2 D3286-3 STUD 54 ALS7-1032-130 INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) 2 2 2 2 AN960JD10L WASHER 2 2 2 2 CCR264SS3-3 RIVET 2 2 2 2 CR3212-4-03 RIVET 2 2 2 2 MS27039-1-08 SCREW MS27039-4-06 SCREW 1 AN960JD416 WASHER 1 52 52 CR3212-4-04 RIVET

S" ~ TOPY UNCS SU

NO.-42422 BS10-10-05

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С

/F NOTES:

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2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER **DART QSI 005 4.4** 

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0,005 TO 0,010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0,150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REV.	DESCRIPTION DE DADT AFROCRAC	BY	DATE
Α	NEW ISSUE	DS	97.03.25
8	AS MANUFACTURED CHANGES	DS	97.06.26
С	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
Ð	REDRAW; INCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
F	DRAWING UPDATED TO CURRENT STANDARDS, SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6, SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08

DESIGN	DS	_∣ DART AEROSPACE USA, II	NC I
DRAWN	SliA	PORT HADLOCK, WA	
CHECKED		DRAWING NO. RE	V. F
MFG. APPR.	E	D2650 SHEET	1 OF 6
APPROVED	10	TITLE	SCALE
DE APPR.	-	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE 08.0	8.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONSTION MOTTO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO MAY OTHER PERSON WRITTEN PERMISSION FROM DUTK TRANSPLACE USA, DETAIL WRITTEN PERMISSION FROM DUTK TRANSPLACE USA, DETAIL WRITTEN PERMISSION FROM DUTK TRANSPLACE USA, DETAIL WRITTEN PERMISSION FROM DUTK TRANSPLACE USA, DETAIL WRITTEN PERMISSION FROM DUTK TRANSPLACE USA.	THAT IT IS WITHOUT

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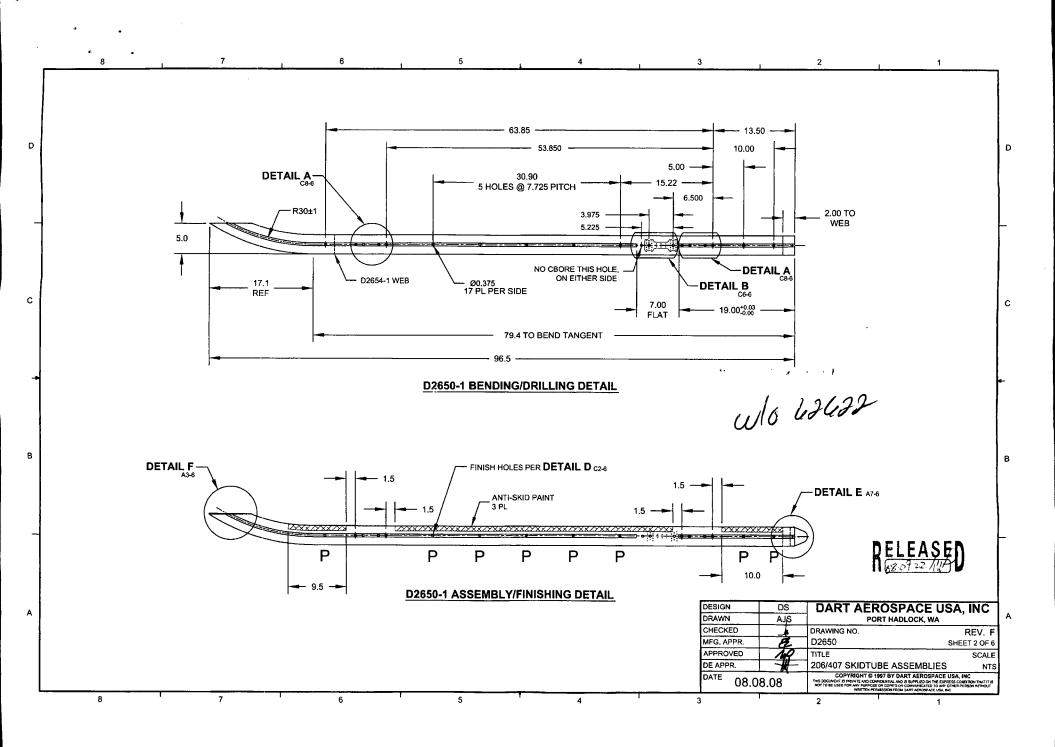
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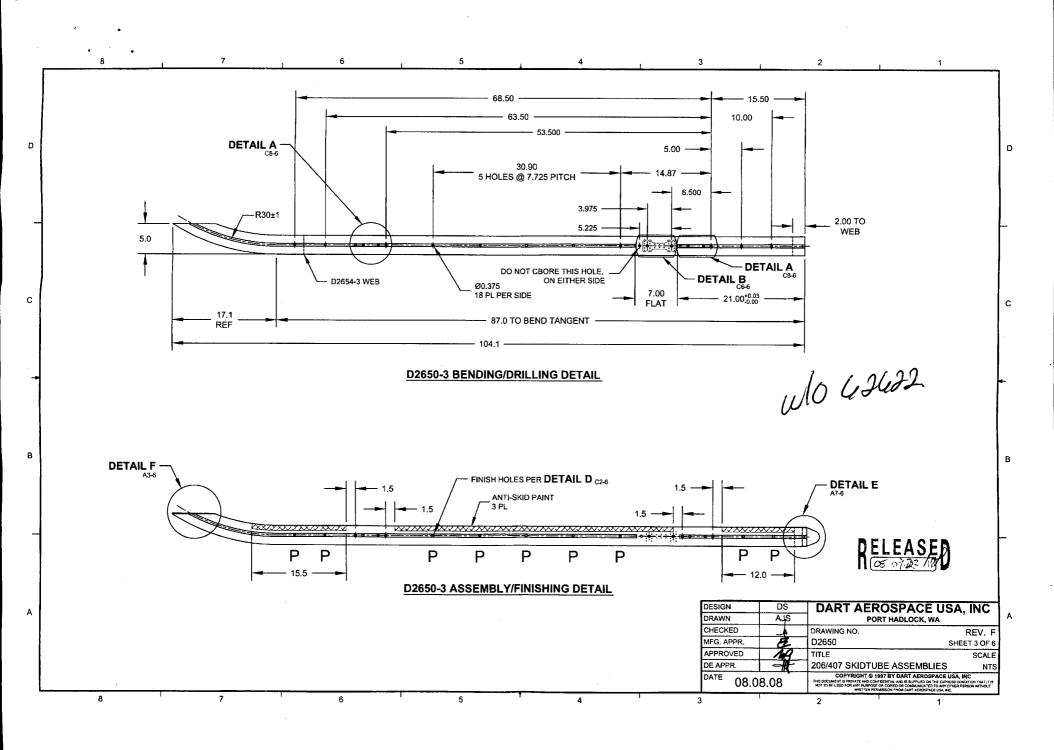
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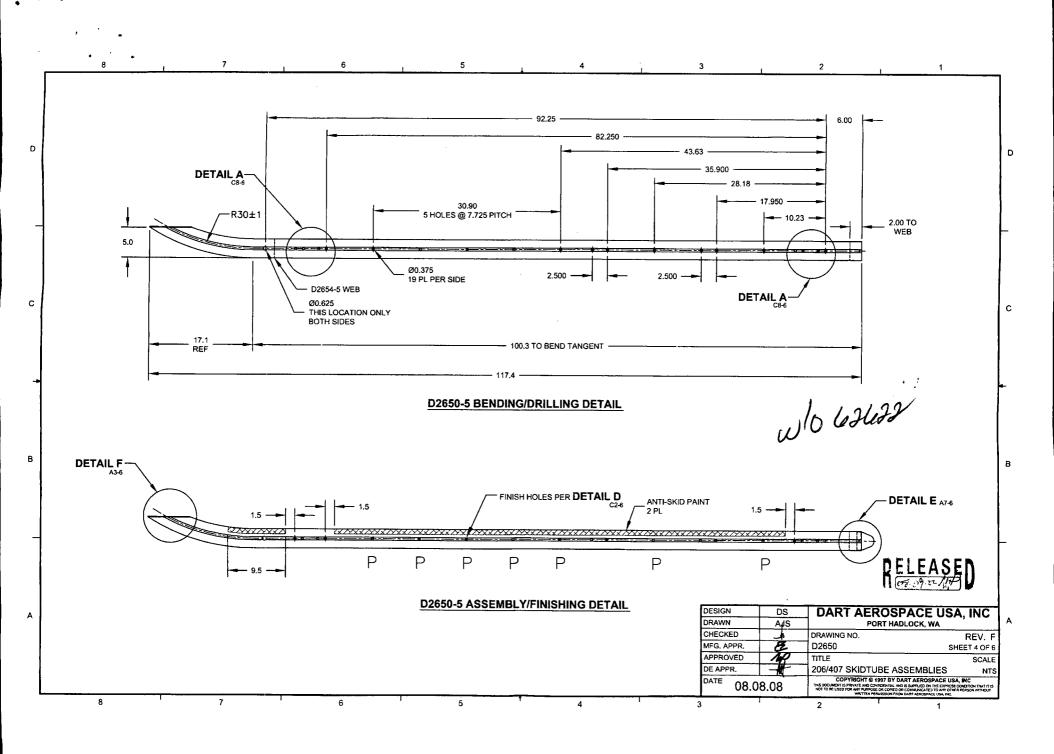
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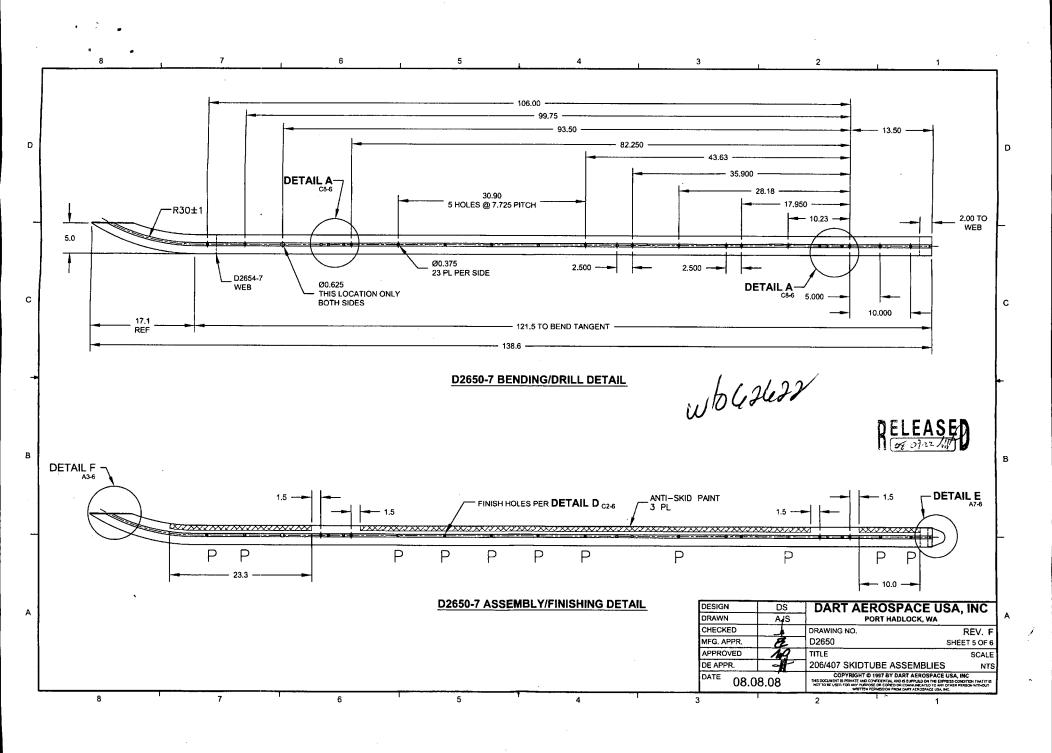
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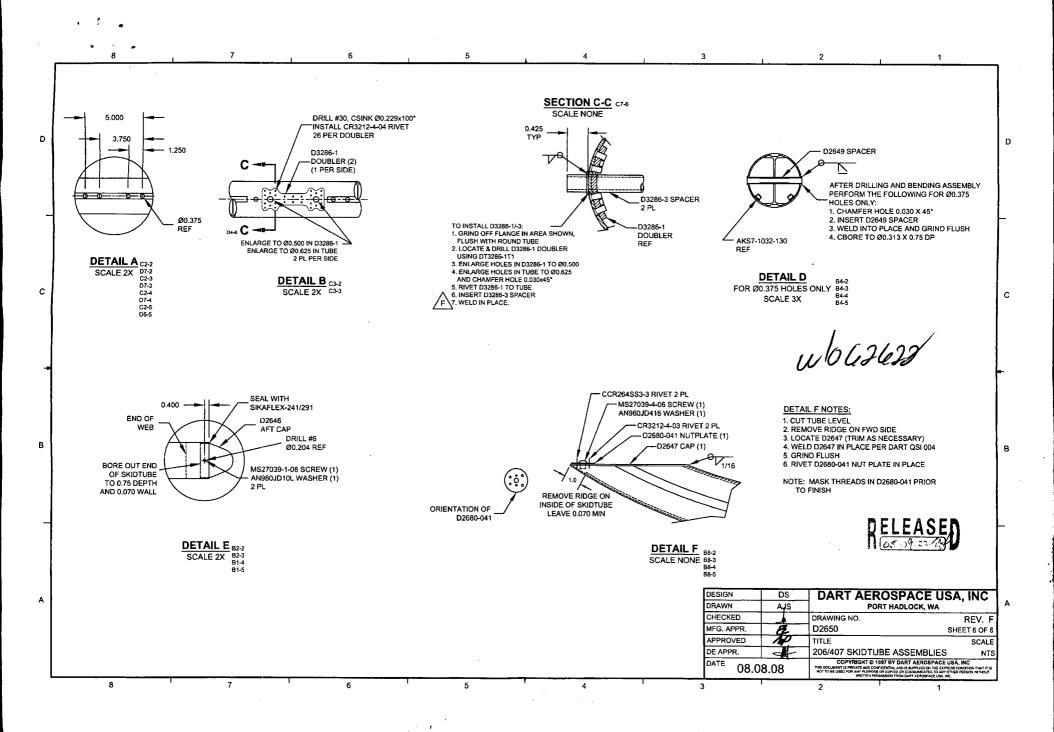
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# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclay Elliott		
Job number: 622808		
Part number: D206 642 · 541		
Description: 206 5kid		
Welding Process: Tig[/ Mig[]	,	*.
Base materiel: Aluminum		•
Current: AC DC ]		

#### TEST REQUIREMENTS AND RESULTS

Visual:	pass[U fail[]
Penetration:	pass[] fail[]
UNACCEPTABLE	
Cracks:	pass[/] fail[]
Undercut:	pass[] fail[]
Pin holes:	pass[,] fail[]
Overlap (cold lap)	pass[/], fail[ ]
Porosity (surface):	pass[] fail[]
Coloration:	pass[1] fail[]
Qualifier Val )	Date of Test Coupon 10.0930
Welder Rodan Elliot	Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.